

**Abstract**

In a method for scanning and cutting sheet-type work material carried on a support surface, the work material is automatically scanned to determine a periphery thereof and to allow for the detection of any flaws within the periphery of the work material. The layout of a marker is then established on the work material and a nesting process for pattern pieces is begun. A first pattern piece is nested onto the work material and a subsequent pattern piece is also nested onto the work material while the first pattern piece is simultaneously cut therefrom. These steps are repeated until all of the pattern pieces are cut from the work material.